

Work Order ID 63792

Monday, November 15, 2010 8:29:46 AM



Page 1

Item ID: D206-559-013

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 11/12/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 11/19/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 10/11/15 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI 9527	rev A
IIN-D206-559	rev K

100 0.00

DOCUMENT CONTROL

DC

Document Control

Memo

0.00

Photocopy bluefile and create labels per PPP D206-559-013 CHG006

for BG 10-12-6
S. 10/12/05

(S)

160

Packaging

Packaging

Pick Kit

0.00

Memo

0.00

10/12/16 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



QC

QC4- 100% Inspect kits for completeness

0.00

8/10/12/6C

Quality Control

180



Packaging

0.00

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD206-559-013 Location:

REV A

190



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, November 15, 2010 8:29:50 AM

Page 1

Work Order ID: 63792



Parent Item: D206-559-013



Parent Item Name: Bearpa

Start Date: 11/12/2010

Required Date: 11/19/2010

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:J 04.02.17 Blank size changed KJ/JLM
IPP Rev:K 07-01-02 Was K10008 JLM
IPP Rev:L 08-01-09 Added Step 2 JLM Verified By:EC
IPP Rev:M 08-04-29 update seq. 8 and 12 DD verified by:EC
IPP Rev:N 08-10-15 New Manufacturing Method JLM Verified
By:EC IPP Rev G 10.10.04 per DSJ19527 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-17A		Purchased	No		160	Each	410.0000	12	60			12/12/2018	Open

AN4-17A

• Bolt

AN4-20A

Bolt

AN960JD416

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST359	410	

Purchased No 160 Each 466.0000 12 60  10124

Location Loc Qty Loc Code
ST359 466

Purchased No 160 Each 24.0000 24 120

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	24	
113300	24	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 63792



Parent Item: D206-559-013



Parent Item Name: Bearpaw.

Start Date: 11/12/2010

Required Date: 11/19/2010

Start Qty: 5.00

Required Qty: 5.00

D2182B



~~x5~~ Rubber Cushion

Manufactured

No

160

f

393.2859

2.5

12.5

10/12/10 sf

~~sf~~

MEAS'D
8/10/10 6

Location

Loc Qty

Loc Code

ST410

393.28594

12.5

52649

43.28594

63413

350

(D2182B050) cut qty (6) at 5.00" as per dwg ***per
kit***

D2274



~~x5~~ Radius Block

Manufactured

No

160

Each

397.0000

12

60

10/12/10 sf

~~sf~~

206 (24") Bearpaw

Manufactured

No

160

Each

3.0000

2

10

63791 sf

D2438



~~x5~~ Clamp

~~sf~~

67

Manufactured

No

160

Each

179.0000

6

30

10/12/10 sf (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Page 3

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Parent Item: D206-559-013



Parent Item Name: Bearpaw

Start Date: 11/12/2010

Required Date: 11/19/2010

Start Qty: 5.00

Required Qty: 5.00

D2529



Washer

Manufactured No 160 Each 481.0000 12



60 (53) B58568 10/12/09

55

D2732



Rubber Extrusion

Manufactured No 160 f 28.6993 2.5



45 12.5 10/12/09

55

50 10 12 06
measured

(D2732-050) cut qty (6) at 5.00" as per dwg ***per
kit***

MS21042L4



Nut

Purchased No 160 Each 2,556.0000 12



60 10/12/09

55

Location	Loc Qty	Loc Code
ST300	2556	
113422	25	
114523	8	
115589	1423	
115621	1100	

60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

5.0 PARTS LIST (D206-559 REV. K)
32.7 PARTS LIST (ICA-D205-559 REV. 2)

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
	X						D206-559-011	Bearpaw Kit 206 A/B
		X					D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			20	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
6		6					D2732-050	RUBBER CUSHION
					2		D3456-1	WASHER
					2		D3859-041	WEARPLATE
					2		D3860-041	WEARPLATE
					2		D4010-041	BEARPAW ASSEMBLY
					8		D4011-1	CLAMP, SHORT
					2		D4011-3	CLAMP, LONG
					8		D4011-5	CLAMP, SHORT (OEM)
					10		D4012-1	CUSHION
					2		AN4C10A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT (WAS AN4-15A)
					4		AN4C13A	BOLT
					8		AN4C15A	BOLT
					8		AN4C17A	BOLT
16	24	16	24				AN960JD416	WASHER (OR NAS1149D0463J)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
					20		MS21043-4	NUT
				8	12		NAS1149D0463J	WASHER (OR AN960JD416)
2		2					QS200M44S	CLAMP

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-O-01	
APPROVED	
BY:	<i>[Signature]</i>
D. SHEPHERD (DE # 02)	
DATE:	10.06.30
CERT. NO.:	SH92-17
ISSUE NO.:	7

DESIGN	<i>gp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>gp</i>		
CHECKED	<i>1</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9527	SHEET 2 OF 2
APPROVED	<i>ND</i>	TITLE	SCALE
DE APPR.	<i>ND</i>	BOLT CHANGE	NTS
DATE	10.06.30	COPRIGHT © 2010 BY DART AEROSPACE LTD	
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